

NCR-7418



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3121-041
Job Sheet 199500



Part No: D3121-041

Job Qty: 8 pcs

Part Name: Bracket Assembly

**Part Weight: 0 lbs**

Status: New

Priority: Medium

Job Created: 8/26/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 8/30/19

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	
100	Bandsaw - 1	8 pcs	8/30/19		0.00	0.11	Bandsaw - 1	SBL 19/09/06
110	HAAS 4 Axis - B4B	8 pcs	8/30/19		1.00	16.02	HAAS - 1 - B4B	SBL / VHS 19/9/18
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	8 pcs	8/30/19		0.00	0.00	QC 2 - 1	VHS 19/9/18
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	



DART
AEROSPACE

Container No: S212104



Part: D3121 - 041
Job No: 199500
Serial No/Batch: S212104
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

DART Aerospace Ltd.
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CANADA
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Date: 09/08/19

Plex 8/26/19 12:06 PM Dart.Renwick.Jennifer

					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
130 QC 8	8 pcs	8/30/19	0.00	0.00	QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B. 19-09-09
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140 Small Fab - 2 - B4B	8 pcs	8/30/19	0.00	0.27	Small Fab - 1 - B4B	DAS
					Small Fab - 2 - B4B	58
					Small Fab - 3 - B4B	Q. 80
					Small Fab - 4 - B4B	SEP 17 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
150 QC 5	8 pcs	8/30/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	

						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	DAS SEP 17 2019 9-89
						QC 5 - 61	
						QC 5 - 81	
160	Packaging 3-1 - Stock - B4B 8 pcs	8/30/19	0.00	0.00	Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B	DAS 28 9-89	
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 - B4B		
					Packaging 3 - 34 - B4B		
					Packaging 3 - 35 - B4B		
					Packaging 3 - 36 - B4B		
170	QC 21 - SA	8 pcs	8/30/19	0.00	0.00	QC 21 - SA - 21	DAS
						QC 21 - SA - 70	21 SEP 17 2019
						QC 21 - SA - 53	9-89
Part Op 100 - Bandsaw - Cut blanks: (1.000" x 2.000") 3.250" long Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine D3121-11 as per Folio FA331 and Dwg D3121 Identify as D3121-11 2- Deburr 3-Scribe batch number 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check							

140 - Small Fab - Assemble D3121-141 as per Dwg D3121.

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location: _____ - Location: CA2

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	2.1680 ft (.271 ea)	100-Bandsaw - 1	S158 304
D3121-21	Bolt	8 pcs (1 ea)	140-Small Fab - 2 - B4B	S200428
D3121-241	Bearing Assembly	8 pcs (1 ea)	140-Small Fab - 2 - B4B	S184720 S176330
				S200405

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.250X2.000	2	16	0
140-Small Fab - 2 - B4B	D3121-21	8	71	0
	D3121-241	8	57	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 199 500
Description: Bracket		Part Number: D3121-11
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.3935	✓		mic	Seb-01
Ø0.201 x 0.100	+/-0.010	.201 x .099	✓		P.g Vern	Seb-05
0.75	+/-0.030	.753	✓		Vern	Seb-05
0.375	+/-0.010	.376	✓		Vern.	11
1.250	+/-0.010	1.246	✓		HG	31000
0.300	+/-0.010	.295	✓		Vern	Seb-05
1.96	+/-0.030	1.966	✓		11	11
Ø0.573	+/-0.010	.575	✓		11	11
0.345	+/-0.010	.345	✓		Vern	11
0.300	+/-0.010	.301	✓		Vern	Seb-05
0.080	+/-0.010	.080	✓		11	11
2.56	+/-0.030	2.558	✓		H.G.	31006
2.14	+/-0.030	2.131	✓		Vern	Seb-05
0.130	+/-0.010	.126	✓		mic	Seb-01
2.57	+/-0.030	2.568	✓		HG	31000
2.85	+/-0.030	2.851	✓		Vern	Seb-05
0.381	+/-0.010	.386	✓		Vern.	11
0.400	+/-0.010	.400	✓		11	11
0.201	+/-0.010	.201	✓		11	11
0.580	+/-0.010	.586	✓		11	11
0.032	+0.000/-0.010	.030	✓		D.G.	Seb-04

Measured by: Seb/VHP	Audited by: [Signature] S.A.	Prototype Approval:	N/A
Date: 19/9/8	Date: 19/9/89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.01	New Issue P/O D3121-041	KJ/EC/DD	
B	08.06.02	Tolerance revised for Ø0.573	KJ/DD	

Entered: ZEDate: Oct 18/19NCR No. 19-7418

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>#199500</u> Part No. <u>199500 D3121-041</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date: <u>19/09/08</u>	Sequence #: <u>120</u>	QTY Affected: <u>X 8</u>		MRB (QSI042) DAS 9 9-89 <u>19-10-04</u>
Description Work Order Deviation		Disposition		Completed By <u>[Signature]</u> <u>19-10-04</u> Lead hand / Supervisor <u>[Signature]</u> <u>19/10/04</u> QC / QA Coordinator DAS 9 9-89 <u>19-10-04</u>
<u>Part lifted off the jig while machining.</u>		<u>Scrap, replace, and destroy</u>		
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☒ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				